

Work Order ID 161813

Tuesday, May 23, 2017 10:29:25 AM

161813

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 6/5/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAY 23 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3915	E								

100 Weld per dwg A/R Aluminum rod Batch: **3131562** 0.00
100 Large Fab

Large Fab

Memo

2.28

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

1x CC 17-6-7

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
QC

Memo

0.00

Quality Control

D 170603 PD

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Large Fab 1- weld (4) corners

① 11.06.08 PD

② ~~11.06.08~~ 21.12.06/08
BER

14 CC 17-6-9

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

Start Date: 6/5/2017 **Start Qty:** 1.00

*** 1 ***

Customer:

Required Date: 6/7/2017 **Req'd Qty:** 1.00

Reference: SCHEDULED/C

Run Start *NB1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NB2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

155

~~QC6-~~ All purchased or subcontracted products

0.00

155

QC

Memo

0.00

Quality Control

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.37

Hand Finishing

1- realodine corners
do not acid etch

(x1) 2017/06/09
BOS

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160	<i>M 137176.</i>					<i>1</i>	<i>0</i>	<i>17-06-12</i>	<i>23 3 38</i>
Powdercoat	Memo	0.19							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to								
	1ST COAT:								
	START TIME: <i>10:10</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>10:40.</i>								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.01							
Quality Control									
						<i>1x</i>	<i>d</i>	<i>17/06/12</i>	<i>DAS 15 0:39</i>

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Assemble as per dwg Memo 1- Install webbing as per dwg 2- Install placard and label as per dwg	0.00 1.26				1x	1	17/06/12	
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			DAG 38 9-89 JUN 13 2017
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.01			04030-043 / 13161811	1x	1	17/06/12	

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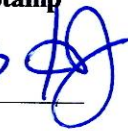
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21 - Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.10							
Quality Control									

17/6/13 

 JUN 13 2017

Picklist Print

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Work Order ID: 161813

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/5/2017

Required Date: 6/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 *D2728-1* Dart Logo Label Small		Manufactured	Yes			180	Each	2.0000	1	1			
									**	(1x) ill 2/05/12			
D2957 *D2957* Mounting Plate		Manufactured	No			100	Each	16.0000	4	4			
									**	ll 17-6-7			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	16	B161750			(4x)			
					138993	1							
					157372	15							
D3915-1 *D3915-1* Rib		Manufactured	No			100	Each	4.0000	2	2			
									**	ll 17-6-7			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	4				(2x)			
					157459	4							
D4016-5 *D4016-5* Hinge Half, Light Lid		Manufactured	No			100	Each	23.0000	3	3			
									**	ll 17-6-7			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	23				(3x)			
					152120	23							

Picklist Print

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/5/2017

Required Date: 6/7/2017

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each 5.0000 3 3

✓ *D4019-3*

Rib

**

CL 17-6-7

Location

Loc Qty

Loc Code

WA004

5

157528

5

D4029-041 Manufactured No

180 Each 7.0000 1 1

D4029-041

Webbing (Long Basket)

**

JUN 14 2017

DAS
6
800

Acceptable to use existing
stock 4/17/6/8

Location

Loc Qty

Loc Code

ST498A

7

154449

1

157452

6

D4035-047 Manufactured No

100 Each 2.0000 2 2

✓ *D4035-047*

Lid Rib Assembly, Aft (Light)

**

CL 17-6-7

Location

Loc Qty

Loc Code

WA004

2

157748

2

✓ D4056-1

Manufactured No

100 Each 12.0000 1 1

D4056-1

Label Plate

**

CL 17-6-7

Location

Loc Qty

Loc Code

WA004

12

157507

12

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/5/2017

Required Date: 6/7/2017

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

2,018.000

34

34

MS20600-AD4W4

**

JUN 14 2017

Rivet

Location

Loc Qty

Loc Code

CCK004

1511

M135704

11

M137412

1000

M137587

500

ST308

42

M137075

42

WA003

465

M135442

204

M136986

108

M137075

153

DAS
6
9-89

NAS1149DN949J

Purchased

No

180

Each

260.0000

34

34

NAS1149DN949J

**

JUN 14 2017

Washer

Location

Loc Qty

Loc Code

ST265

260

m136781

110

m137075

150

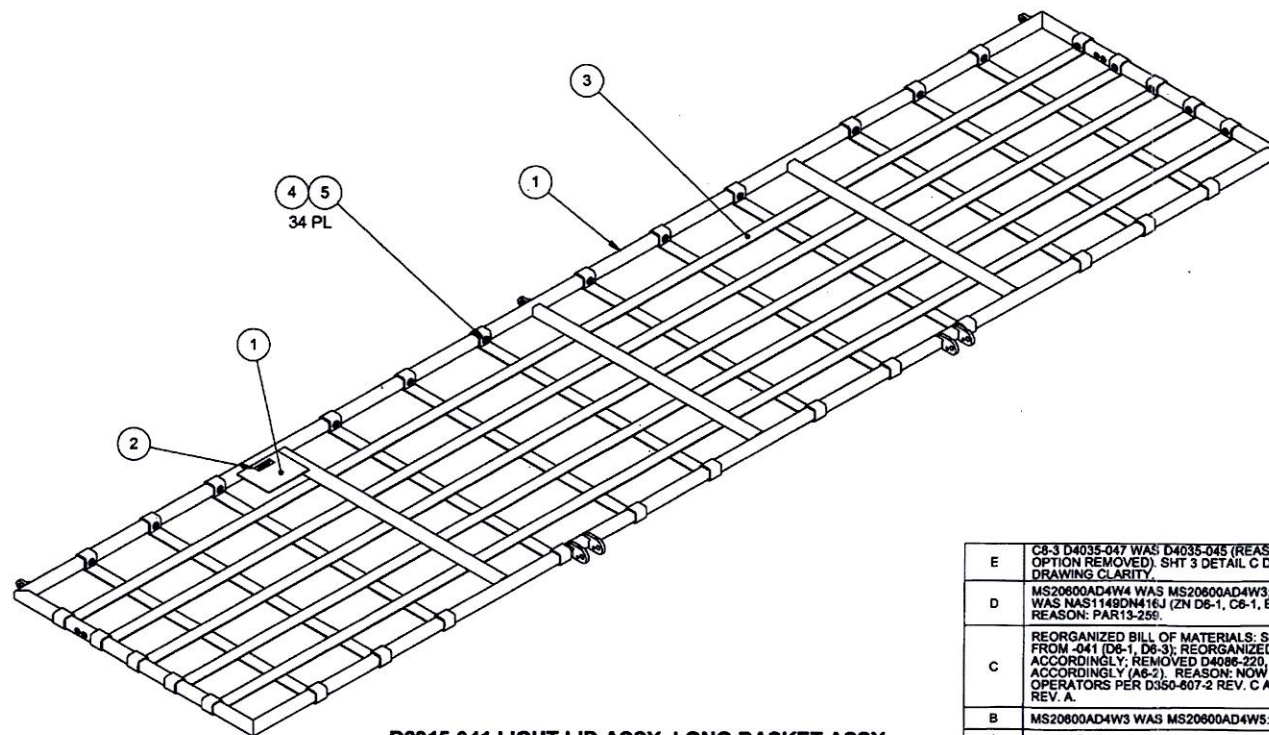
DAS
6
9-89

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

SHOP COPY

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SUBJECT TO AMENDMENT

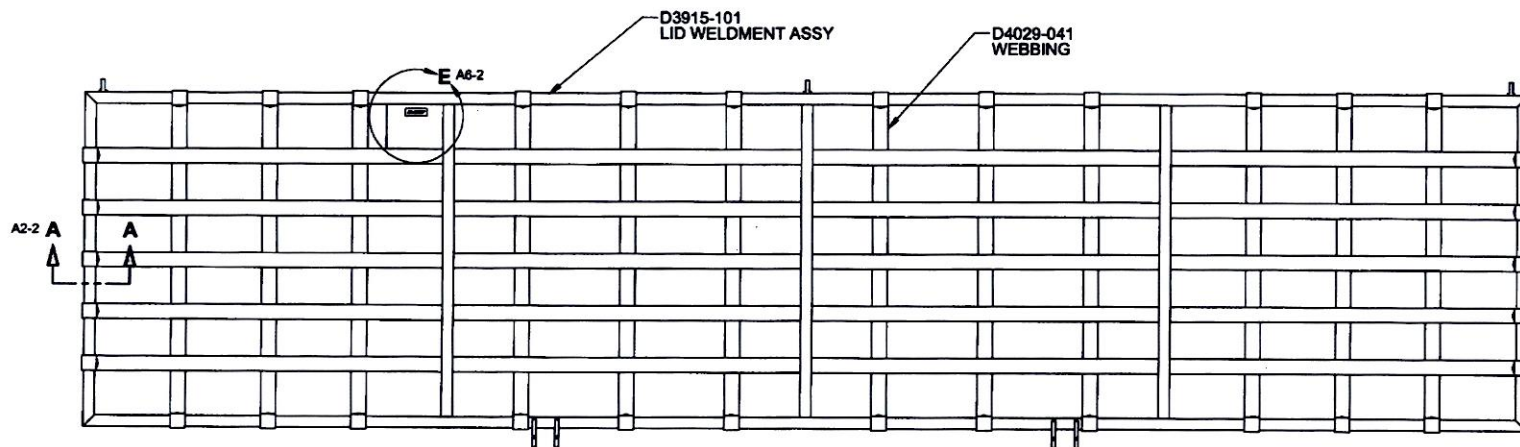
WITHOUT NOTICE

WORK ORDER

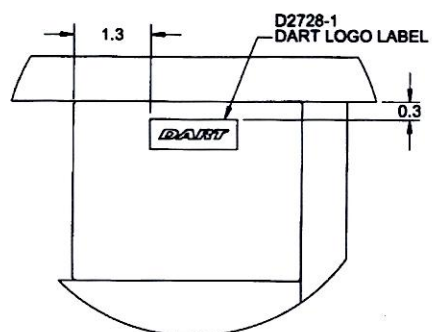
MAY 23 2017

RELEASED
2013-08-16

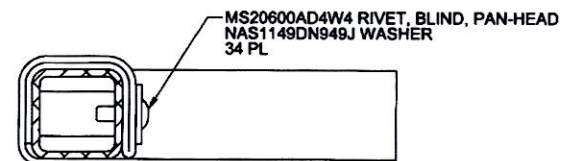
E	C8-3 D4035-047 WAS D4035-045 (REASON PROFORM OPTION REMOVED); SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-255.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 REV. E SHEET 1 OF 4 TITLE LIGHT LID ASSY-LONG BASKET SCALE INTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	UP		
MFG. APPR.	MA		
APPROVED	MA		
DE APPR.	MA	DATE 13.07.18	



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

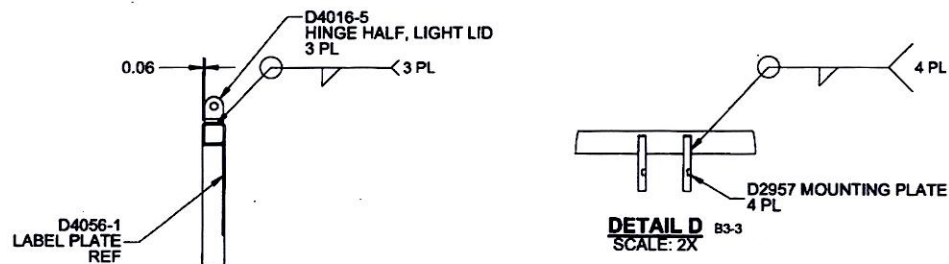


SECTION A-A C8-2
SCALE: 8X

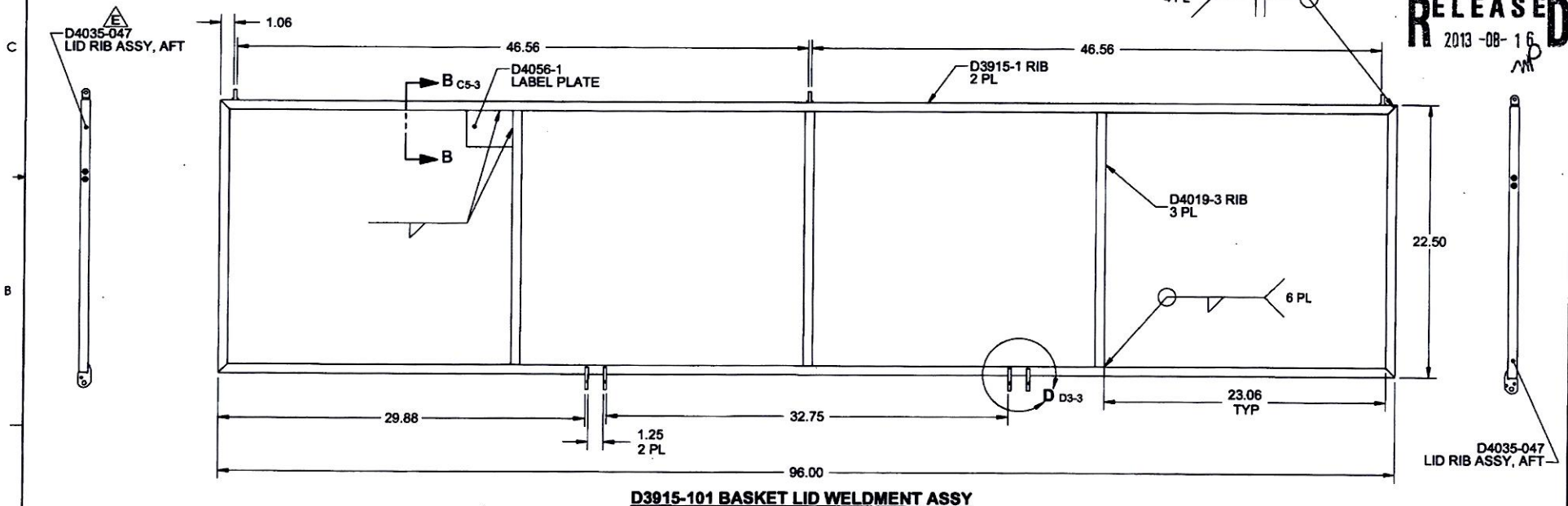
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2013-08-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	4/1	DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	Nts
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



DETAIL D
SCALE: 2X

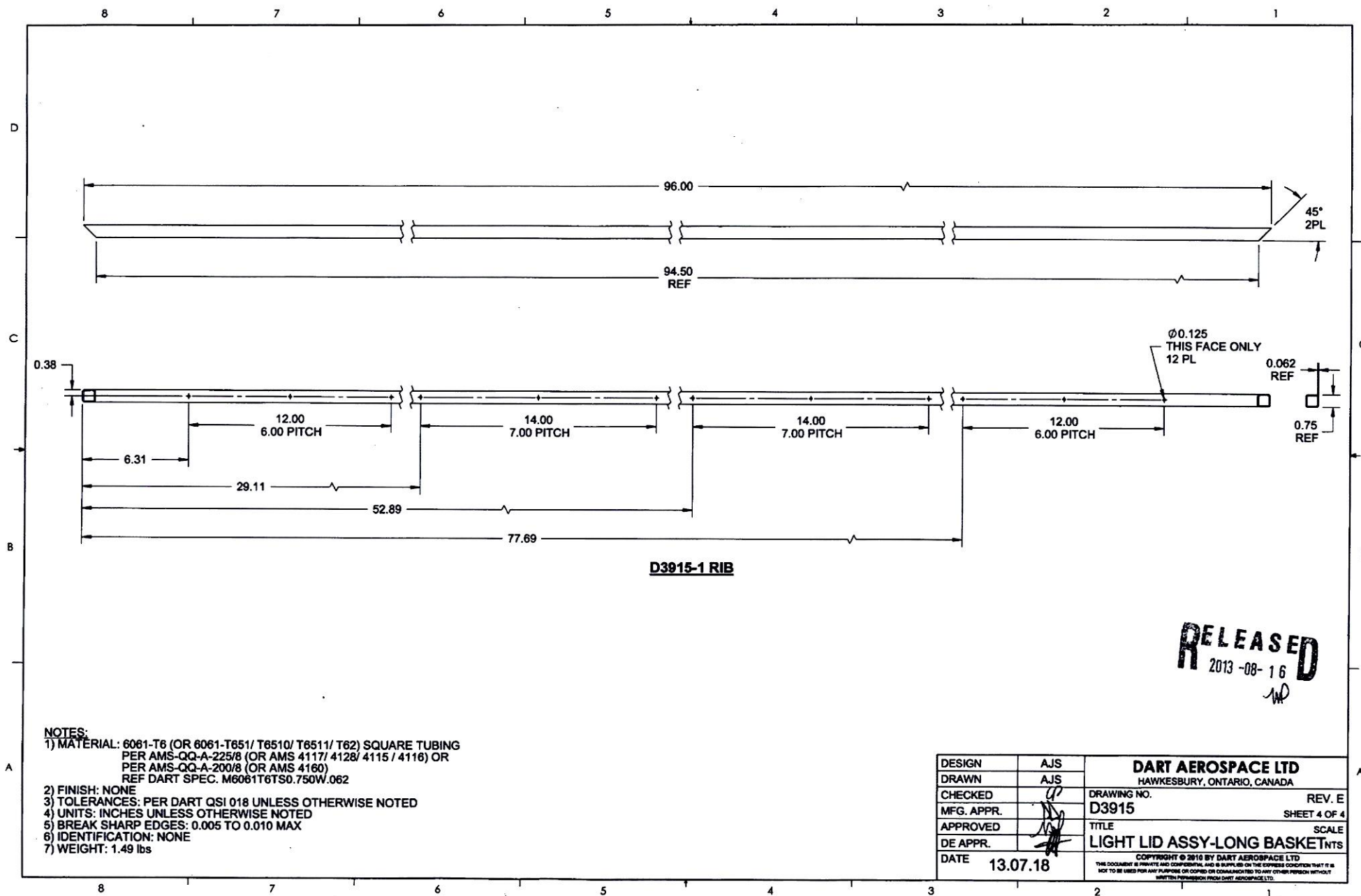


RELEASED
2013-08-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET NTS	
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3915	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKETNTS	
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